



Dart Aerospace Ltd.
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Canada

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D4931-1
Job Sheet 185023



LOAD

Part No: D4931-1

Job Qty: 4 ea **12**

DAS
21
9-89

Part Name: Engine Fitting (for acft models B2 & previous)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-3		
100	Doosan	4 pcs	11/2/18	11/2/18	0.36	5.00	Doosan		
110	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-3		
120	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-3		
130	Packaging	4 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2 5/127		DEC 11 2018
140	QC21-SA	4 Ea	11/2/18	11/2/18	0.00	0.00	QC21		DAS 21 9-89 DEC 11 2018 DEC 11 2018

Part Op
Descriptions: 100 - Machine as per folio FB210

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	1 ft (.25 ea)	90-Start up Operation	50/B010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	1	29	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 8:59 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 185023
Description: EAPS P2 Engine Fitting		Part Number: D4931-1
Inspection Dwg: D4931	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x +/-0.5°	.06 x 45°				
0.362	+/-0.010	.362				
0.088	+/-0.010	.090				
0.08	+/-0.030	.085				
0.25	+/-0.030	.252				
0.50	+/-0.030	.504				
Ø0.063	+0.004/-0.001	.065				
0.125	+/-0.010	.130				
0.424	+/-0.010	.422				
0.315	+/-0.010	.315				
0.185	+/-0.010	.186				
37°	+/-0.5°	37°				
1.283	+/-0.010	1.285				
1.250	+/-0.010	1.250				
Ø0.472	+0.006/-0.001	.4745				
Ø0.670	+0.000/-0.001	.667				
0.500	+/-0.010	.5				
0.950	+/-0.010	.958				
Ø0.609	+0.008/-0.001	.6085				
0.938	+0.000/-0.005	.9355				
1.804 Ref	+/-0.010	1.815				
1-1/16-12 UN 2A	N/A				Jig AN 18	DOOJAN
M18 x 1.5 Thread	N/A					
Wire Size 0.55	Max 1.099 ⁵ Min 1.093 ⁸	1.097				
Wire Size 0.040	Max 0.737 ⁸ Min 0.732 ³	.736			Go/No Go	

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 18/12/09	Date: 18/12/11	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	[Signature]
B	16.05.30	Dimensions updated	KJ	[Signature]



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Container No: S135837



Part: D4931-1

Job No: 185023

Serial No/Batch: S135837

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/09/10